

Date: Tuesday, 5/16/2006 10:41:02 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE		
Job Number	: 27149		Part Number	: D29332		
Estimate Number	: 10834		Drawing Number	: D2933 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 5/16/2006 S.O. No. : N/A		Drawing Revision	: B		
Prsh Rev.	: NC		Material	: N/A		
First Issue	: N/A Type : MACHINED PARTS		Due Date	: 6/5/2006 Qty: 6 Um: Each		
Previous Run	: 26369					
Written By	: <i>See A comment Below</i>					
Checked & Approved By	: <i>JK 06-05-16 N</i>					
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101001	7075-T7351 2X6X6.25	
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No: <i>B25342</i></p> <p style="text-align: right;"><i>JL 06/06/12</i></p>			
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
<p>Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 5-Deburr</p> <p style="text-align: right;"><i>JL 06/06/12</i></p>			
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
<p>Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet</p> <p style="text-align: right;"><i>JL 06/06/12</i></p>			
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
<p>Comment: INSPECT ALL DIM TO DIM SHEET</p> <p style="text-align: right;"><i>JL 06/06/12</i></p>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/06/21

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Tuesday, 5/16/2006 10:41:03 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 27149

Part Number: D29332

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

TMZ 06/06/12 6

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06/06/12 6

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/06/12 6

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

C204/20/06 ⑥

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 475

C204/20/06 ⑥

10.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

⑥ 06/06/12

Job Completion



⑥ 06/06/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	27149
Description: 206 Saddle, Inboard, Right side		Part Number:	D2933-2
Inspection Dwg: D2933 Rev. B		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.116	.120	.120	.119		
B	0.100	0.140		.117	.120	.121	.120		
C	0.100	0.140		.122	.130	.128	.129		
D	0.210	0.230		.223	.225	.226	.225		
E	1.245	1.255		1.249	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.249	1.250	1.249		
G	2.495	2.505		2.500	2.500	2.501	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.578		
J	2.495	2.505		2.501	2.500	2.501	2.501		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		.239	.238	.239	.239		
N	0.100	0.140		.122	.126	.126	.126		
O	0.540	0.560		.550	.550	.550	.551		
P	0.490	0.510		.501	.501	.503	.504		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		.258	.257	.257	.258		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.630	1.630	1.629	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.366		
W	0.316	0.321	DT8690						
X	1.125	1.145		1.133	1.135	1.135	1.136		
Y	1.565	1.585	DT8695 A/B						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L.	Audited by:	M.R.
Date:	06/06/11	Date:	06/06/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#

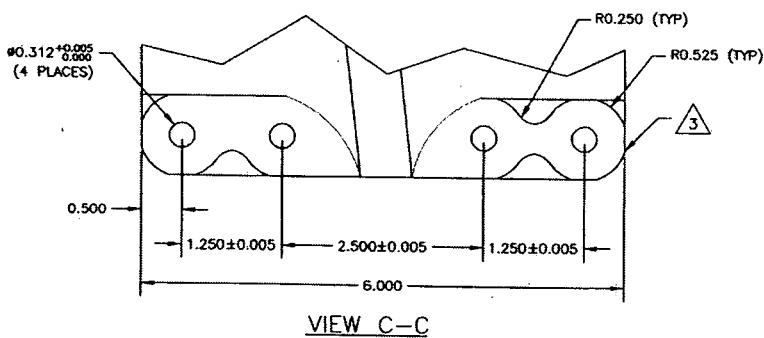
DART AEROSPACE LTD		Work Order:	27149
Description: 206 Saddle, Inboard, Right side		Part Number:	D2933-2
Inspection Dwg: D2933 Rev. B			Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

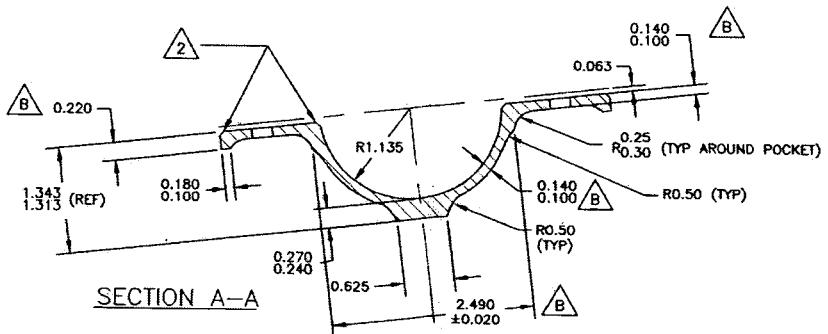
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.119	.119				
B	0.100	0.140		.118	.119				
C	0.100	0.140		.128	.126				
D	0.210	0.230		.228	.227				
E	1.245	1.255		1.250	1.249				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.499				
H	0.510	0.515		.514	.514				
I	1.572	1.582		1.578	1.576				
J	2.495	2.505		2.501	2.500				
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686	/	/				
M	0.235	0.240		.240	.239				
N	0.100	0.140		.126	.127				
O	0.540	0.560		.551	.551				
P	0.490	0.510		.505	.503				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.500	2.500				
S	0.240	0.270		.258	.258				
T	0.100	0.180		.145	.145				
U	1.625	1.635		1.630	1.629				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321	DT8690						
X	1.125	1.145		1.136	1.135				
Y	1.565	1.585	DT8695 A/B						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L	Audited by:	QML
Date:	06/06/12	Date:	06/06/12

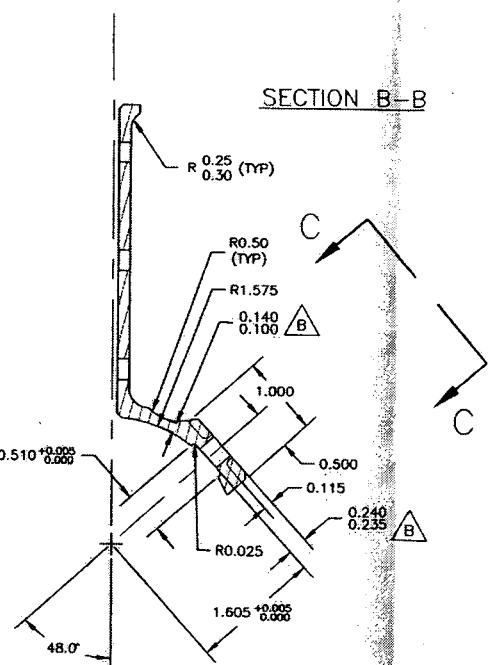
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#



VIEW C-C



SECTION A-A

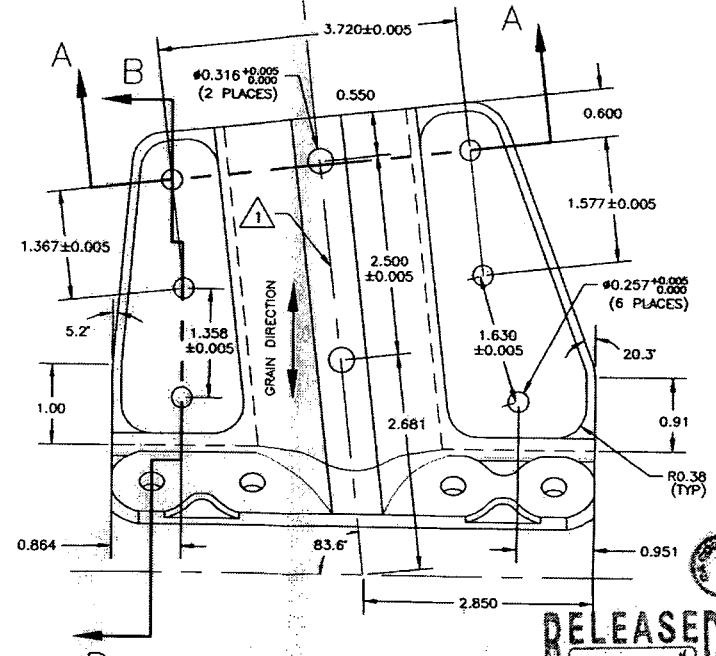


SECTION B-B

D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI-018 UNLESS OTHERWISE NOTED.

- 1** ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2** CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYP 2 PLACES)
- 3** CHAMFER 0.050" x 45°



RELEASED
02-05-31 *

B	00.05.29	CHANGED GEOMETRY AND MATERIAL		
A	99.10.29	NEW ISSUE		
DESIGN	DRAWN BY <i>RF</i>	DART	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED	APPROVED <i>RF</i>	DRAWING NO. D2933	REV. B SHEET 1 OF 1	
DATE	00.05.29	TITLE SADDLE INSIDE	SCALE	2-3

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NO 27149